



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-706-013
Job Sheet 169685



Part No: D205-706-013

Job Qty: 1 ea

Part Name: Fuel Purge Canister



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/18/17

Job Tracking No:

Due Date: 12/21/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Rotorcraft Support Inc (CROTO01)

16425 Hart Street Van Nuys, CA, 91406 USA ph:(818) 997-7667 fx:(818) 997-1513.

Note: DWG REV B SHEETS 19-20 IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJ/JLM IPP
Rev:F 10.05.10 as per chg002 DD verified :EC IPP Rev:G 12.12.07 as per IIN revB DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/21/17	0.00	0.00	Start Up Stores/Pkg-2		
110	Packaging	1 pcs		12/21/17	0.00	0.00	Packaging1-2		
120	QC	1 pcs		12/21/17	0.00	0.00	QC4		
125	DC	1 pcs		12/21/17	0.00	0.00	DC		
130	Packaging	1 pcs		12/21/17	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		12/21/17	0.00	0.00	QC21		

Part Op 125 - Photocopy bluefile and create labels per PPP D205-706-013 CHG003
Descriptions: 130 - Identify and pack for shipping as per PPPD205-706-013 Location : FG018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	5032296-AN3-5A	4	471	0	0
	74134405-AN814-6D	1	9	0	0
	74137507-AN815-6D	2	15	0	0
	5032288-AN833-6D	3	9	0	0
	5032281-AN924-6D	4	11	0	0
	5032272-D2001-4	1	4	0	0
	5032274-D3262-041	1	4	0	0
	7160397-D3264-1	2	2	0	0
	5032268-D3297-1-0121	1	3	0	0
	5032265-D3297-1-0130	1	2	0	0
	7144149-D3297-3-0350	1	3	0	0
	5032260-D3298-001	1	3	0	0
	5032259-D3298-009	1	7	0	0
	5032256-D3299-1	1	9	0	0
	5032253-D3299-3	1	3	0	0
	5032252-D3301-1	1	3	0	0
	5032254-D3301-3	1	3	0	0
	5032248-D3302-1	1	3	0	0
	5032242-D3302-3	1	2	0	0
	5032236-MS21042L3	4	4,112	0	0
	5032229-MS21919-WDG12	1	30	0	0
	5032325-MS21919-WDG16	2	20	0	0
	5032224-MS21919-WDG9	5	86	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

5032217	MS21920-42	2	6	0	0
5032201	MS29512-06	5	8	0	0
5032194	MS35489-11	1	12	0	0
5032176	NAS1149D0332J	4	3,927	0	0
5032144	NAS1149D0363J	8	4,643	0	0
5032149	NAS1149D0963J	2	40	0	0

Part Specifications

Specifications could not be found.

Plex 12/18/17 3:54 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
 S032328 Fuel Purge Canister Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com PART NO: Original Serial #: S032328 Revision: Operation: Change No: D205-706-013 Start up Operation CHG003 01/15/18 Job No: 169685		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			
Environment ☐	No Re-verificati ☐		
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setup ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐		
Material ☐	Use for Testing ☐		
Internal Transport ☐	Poor Information ☐		
Tribal Knowledge ☐	Rushing ☐		
LOA ☐	Product Improvemen ☐		
Substation ☐	Process Improvement ☐		
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		
OTHER : _____		e ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	

REFERENCE ONLY

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214/EAGLE SINGLE)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
		2	D2026-101	SCREW
	1	1	D3262-041	CANISTER ASSEMBLY
1			D3262-043	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
1	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
	1		D3298-001	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1			D3299-7	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
1			D4054-001	TUBE ASSEMBLY
1			D4054-003	TUBE ASSEMBLY
1			D4054-009	TUBE ASSEMBLY
4	4	4	AN3-5A	BOLT
	1	1	AN814-6D	PLUG
1			AN814-8D	PLUG
2	2	2	AN815-6D	UNION
1			AN815-8D	UNION
		1	AN816-6D	NIPPLE
2	3	1	AN833-6D	ELBOW

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Revision: B

Date: 12.11.06

Qty -011	Qty -013	Qty -015	Part Number	Description
1			AN833-8D	ELBOW
		1	AN919-6D	REDUCER
4	4	1	AN924-6D	NUT
1			AN924-8D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10	WASHER
2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS21920-42	CLAMP
7	5	5	MS29512-06	O-RING (OR M83248/1-906)
3			MS29512-08	O-RING (OR M83248/1-908)
	1	1	MS35489-11	GROMMET
1			MS35489-16	GROMMET

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D205-706-013 Revision: Fuel Purge Canister														
140	QC21-FG	S032328	169685	1 Ea	0	S032328	FG018		Stock	1/15/2018	Issue Container			
Operation Totals:		1		1	0									
Part Totals:		1		1	0									
Part Number: MS21919-DG16 Revision: Clamp														
100	Receive Ea	F17123.0	169685	2 Ea	0	17123	ST294		Stock	10/18/2017				
Operation Totals:		1		2	0									
Part Totals:		1		2	0									
Part Number: NAS1149D0332J Revision: Washer														
100	Receive Ea	S032176	169685	4 Ea	0	PO038585	Start Up Stores/Pkg-2		Stock	1/15/2018	Issue Container			
Operation Totals:		1		4	0									
Part Totals:		1		4	0									
Part Number: NAS1149D0363J Revision: Washer														
100	Receive Ea	S032144	169685	8 Ea	0		Start Up Stores/Pkg-2		Stock	1/15/2018	Issue Container			
Operation Totals:		1		8	0									
Part Totals:		1		8	0									
Totals:		4		15	0									